

Date: Tuesday, 03/10/2006 11:48:55 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 28822	Part Number	: D35381
Estimate Number	: 12543	Drawing Number	: D3538 UNDER REV
P.O. Number	:	Project Number	: N/A
This Issue	: 03/10/2006	Drawing Revision	: UNDER REVIEW
Prsht Rev.	: NC	Material	:
First Issue	: /	Due Date	: 10/10/2006 Qty: 2 Um: Each
Previous Run	:		
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-10.03 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
	Comment: Qty.: 0.1995 f(s)/Unit Total : 0.3990 f(s) 6061_T6 Bar 0.750 x 1.500 Batch: M15031	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: 1-Machine as per Folio FA651 and Dwg D3538	
	2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

AM 06-10-04

(2)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 04

(2)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Bac - 10-06-04

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U do cool

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

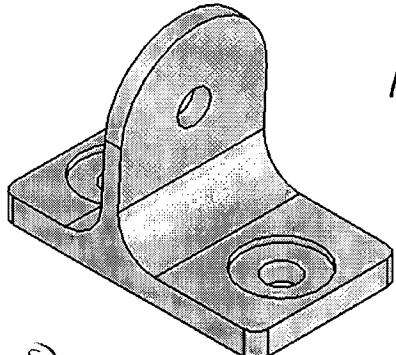
NOTE: Date & initial all entries

PRELIMINARY ISSUE

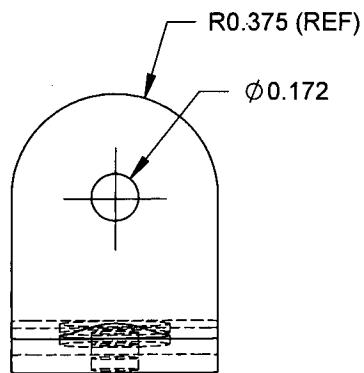
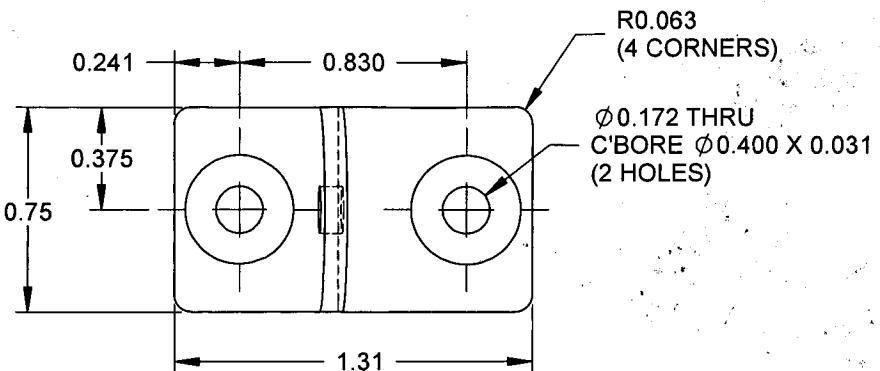
UNDER REVIEW

56 J7.18 LE

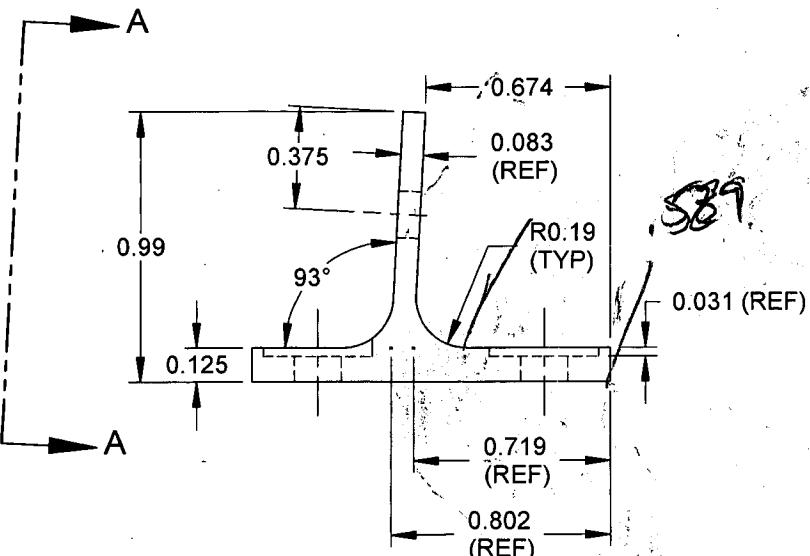
DESIGN CE	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3538	REV. A SHEET 1 OF 1
DATE 06.09.05		TITLE HINGE BRACKET	SCALE 1:1
REV A	DATE 06.09.05	DESCRIPTION NEW ISSUE	



M15031
6061-T6 1.50 X .75



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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WATERFALL

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	D5538-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	06.10.03	Date:	06.10.04		Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	